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**PROCESS FOR PREPARING AN OVER MOLDED
MOTOR STATOR STRUCTURE**

ABSTRACT OF THE DISCLOSURE

A process for preparing an over molded motor stator structure comprises constructing a bobbin assembly; constructing an intermediate stator assembly including assembling the bobbin assembly to a stator core having an internal and external diameter; disposing the intermediate stator assembly into a mold fixture comprising a cover half and an ejector half that includes an inner ejector core and a moveable plate; loading a bearing carrier into the mold fixture; closing the cover half causing the moveable plate to travel within the mold; injecting a unitizing material into the mold fixture to encapsulate the intermediate stator assembly and form an over molded motor stator structure.

The moveable plate travels within the mold fixture so as prevent coating of the stator laminations external diameter. A tight tolerance relationship between the inner ejector core and the stator lamination inner diameter prevents the internal diameter from being encapsulated by the unitizing material.

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